

Date: Tuesday, 27/01/2009 12:59:31 PM  
User: Linda Lacelle

**Process Sheet**

**Customer** : CU-DAR001 Dart Helicopters Services **Drawing Name** : LUG ASSEMBLY 206L/407 GHW LUG  
**Job Number** : 45294  
**Estimate Number** : 10318  
**P.O. Number** :  
**This Issue** : 27/01/2009 **S.O. No.** :  
**Prsht Rev.** : NC **Part Number** : D2659  
**First Issue** : / / **Type** : PURCHASED PARTS **Drawing Number** : D2659 REV A  
**Previous Run** : 44217 **Project Number** : N/A  
**Material** :  
**Due Date** : 20/02/2009 **Qty:** 12 **Um:** Each  
**Written By** :  
**Checked & Approved By** :  
**Comment** : Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF

**Additional Product**

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 D2657 Lug



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Lug B35662 x4

EL 9-2-11

2.0 D2658 Lug Assembly



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Lug Assembly B43885 x4

EL 9-2-11

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



**Comment:** LARGE FABRICATION RESOURCE 1

(x4)

1-Weld as per Dwg D2659 using location Jig DT8208  
A/R Steel Rod M108350

EL 9-2-11

4.0 QC9 VISUAL WELDING INSPECTION



**Comment:** VISUAL WELDING INSPECTION

lpc 09.02.12

(x4)

5.0 QC5 INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT WORK TO CURRENT STEP

S 09.02.12 (x4)

6.0 SPRAY PAINTING SPRAY PAINTING



**Comment:** -PRIME GREY B# 110199  
-SPRAY PAINT DELFLEET BLUE B# 110077  
-CLEAR DELFLEET B# 110161

ml 09 02 12

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 45294

Part Number: D2659

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

RT 09-02-13 (x4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 420

9/2/13

SA

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17 H

Job Completion



MF 09-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

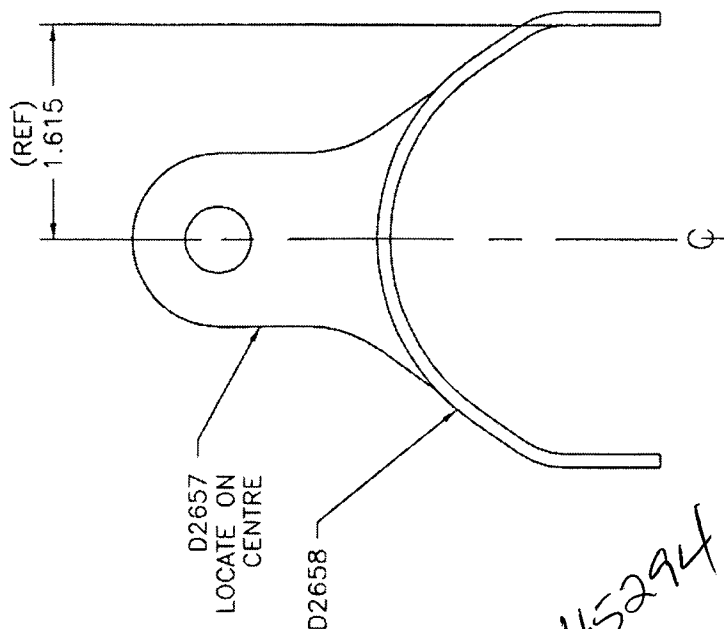
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

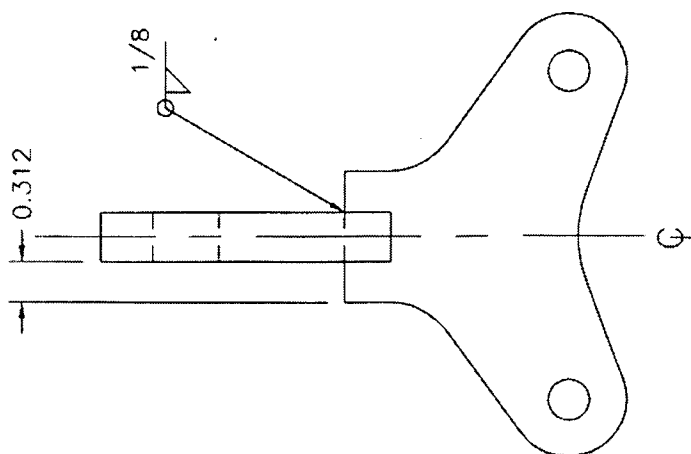


DESIGN <i>D18</i>	DRAWN BY <i>D18</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2659	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG ASSEMBLY	SCALE NTS
A	97.11.03	NEW ISSUE	

RELEASED  
47/11/06 DS



45294



D2659 LUG ASSEMBLY

WELD PER DART QSI 004  
FINISH: POWDER COAT PER DART QSI 005 4.4  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTRE-LINES (CL)